

-021 Blue

Dart Aerospace Ltd.

38

Date: Tuesday, 8/21/2007 2:01:00 PM  
User: Kim Johnston

### Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	206L /407 STEP ASSY, LH
Job Number	34129A	Part Number	D2724041 Bl
Estimate Number	11702	Drawing Number	D2724 REV C
P.O. Number	NA	Project Number	NA
This Issue	8/21/2007	S.O. No.	NA
Prsht Rev.	NC	Drawing Revision	C
First Issue	NA	Material	NA
Previous Run	33756A	Due Date	9/20/2007
Written By		Qty:	3 Um: Each
Checked & Approved By			
Comment	Est Rev:E As Per Ecn 766 06-01-06 JLM		

#### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Qty	Part #	Description	Batch
1	D2622-120C	Extrusion	332858

Check Material for any Dents or Defects

a.m 07.09.10

3

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-1 using D2622 extrusion as per Dwg D2724

Deburr and bevel ends for welding

a.m 07.09.10

3

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	333861

J.E. 07.09.11

3

4.0 D34581 PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3458-1	Plate	334179

J.E. 07.09.11

3

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 2:01:00 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 34129A

Part Number: D2724041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D34583 PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3458-3 Plate 334180

16.07.09.11

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by Jig

DT (One End Only) m103794

A/R AL ROD Batch: m103794  
m104721

16.07.09.11

Grind end cap welds flush

16.07.09.13

7.0 QC9 VISUAL WELDING INSPECTION



16.07.09.13 3

Comment: VISUAL WELDING INSPECTION

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.07.09.13 3LH

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

16.07.09.13

3X

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16.07.09.13

11.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

16.07.09.18

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-COMFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 2:01:00 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 34129A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remainig end cap as per Dwg D2724 using Jig DT followed by Jig  
DT  
A/R AL ROD Batch: M103794

Grind per dwg D2724

a.m 07.09.20 3

SL 07.09.18 3

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-09-20 (3)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SL 07.09.20 + 3LH

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

(3LH)

Touch up Alodine

BL 07.09.20

15.0

SPRAY PAINTING

SPRAY PAINTING



Comment: Issue P.O 4650

Atelier Debosselage

c20/09/21

07/09/21 (3)

Spray Paint Delfleet Blue  
Clear with Delfleet

3

16.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

SL 07.09.25

(3LH)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



m105694

SL 07/09/25 (3)

Comment: Wing Walk as per Dwg D2724 and QSI 00 54.4

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SL 07/09/24 (3)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/02/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 2:01:01 PM  
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## Process Sheet

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Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 34129A

Part Number: D2724041

Job Number:



Seq. #: Machine Or Operation:

Description :

19.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

PP

Location:

34129

08/21/26

(3)

20.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/21/26

Job Completion



6 08/26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			
					*				

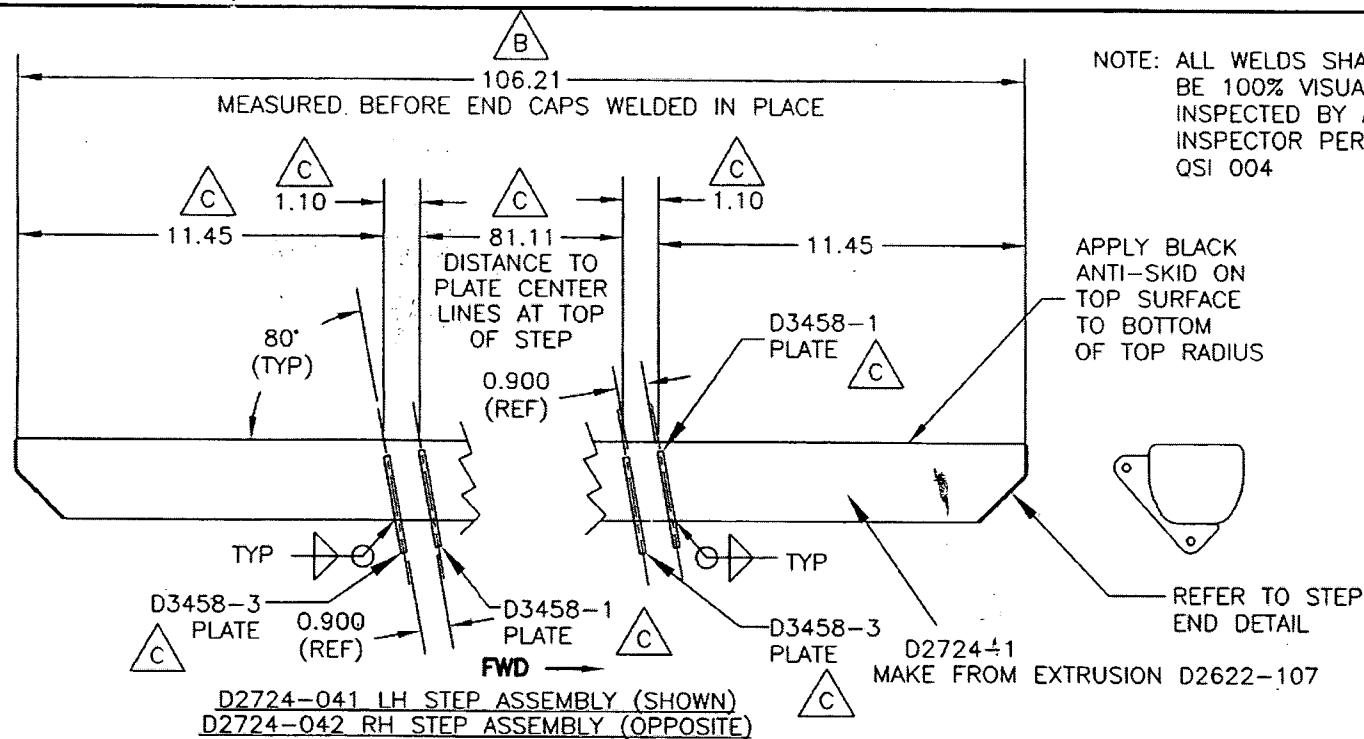
NOTE: Date & initial all entries

**DART**

NOTE: ALL WELDS SHALL  
BE 100% VISUALLY  
INSPECTED BY A QUALIFIED  
INSPECTOR PER DART  
QSI 004

**RELEASED**  
OK 11/14

DESIGN <b>KE</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA
CHECKED <b>M</b>	APPROVED <b>M</b>	DRAWING NO. <b>D2724</b>
DATE <b>05.09.19</b>	TITLE <b>206L/407 STEP ASSEMBLY</b>	REV. C SHEET 1 OF 1
<b>A</b>	97.12.04	SCALE NTS
<b>B</b>	98.10.19	NOTES UPDATED WELD DETAIL REVISED TOLERANCES
<b>C</b>	05.09.19	RE-DESIGN, ADD D3458-1/-3



### D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
X		D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

### D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED